

What is claimed is:

1. A continuous ceramic composite plating method for long doctor base materials comprising: a degreasing step; rinsing step; acid immersion step; rinsing step; electroless ceramic composite nickel plating step; plating solution collection step; rinsing step; and drying step between a first step of supplying continuously a long doctor blade base material held on a material reel spirally while the blade surface is maintained in a horizontal direction with respect to the surface of a solution and a final step of taking up continuously the blade base material on a corresponding take-up reel while the blade base material is cramped by a plurality of pinch rolls.

2. A continuous ceramic composite plating method for long doctor base materials comprising: a degreasing step; rinsing step; acid immersion step; rinsing step; electroless ceramic composite nickel plating step; plating solution collection step; rinsing step; and drying step between a first step of supplying continuously a plurality of long doctor blade base materials held on a plurality of material reels spirally while the blade surfaces are maintained in a horizontal direction with respect to the surface of a solution and a predetermined interval therebetween is maintained and a final step of taking up continuously the plurality of doctor blade base materials on a plurality of corresponding take-up reels while the plurality



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tank; electroless ceramic composite nickel plating tank; plating solution collecting tank; rinsing tank; and drying tank between the material reels and the take-up reels.

6. The doctor blade plating apparatus according to claim 5, wherein a space tank is disposed between the respective treatment tanks, and a partition plate having a slit portion through which a single blade can pass or a plurality of parallel slit portions through which a plurality of blades can pass with maintaining a predetermined interval therebetween is used to separate each treatment tank from each space tank.

7. An apparatus for continuously producing baked long doctor materials comprising: a plurality of pinch rolls for continuously forwardly straightening out long doctor materials plated by the method according to claim 1 or 2 from the take-up reel; and a straightening furnace for baking through which the straightened plated blades pass.

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